

# Work Order ID 54008

November 25, 2009 3:05:00 PM



Page 1

Item ID: D2594-1

Revision ID: C

Item Name: Plug, 205 Skidtube

Accept



Setup Start



Stop



Start Date: 11/25/09 Start Qty: 120.00

Required Date: 11/30/09 Req'd Qty: 120.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2594

Rev C

100

0.00



Hardinge CNC LATHE SMALL

0.00

*SA 09/11/26*

121



Hardinge

Memo

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

*SA 09/11/26*

121



QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

*SA 09/11/26*

121



QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54008

November 25, 2009 3:05:00 PM



Item ID: D2594-1  
Revision ID: C  
Item Name: Plug, 205 Skidtube

Accept



Setup Start



Stop



Start Date: 11/25/09 Start Qty: 120.00  
Required Date: 11/30/09 Req'd Qty: 120.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



BR 09-11-27

0.00

HandFinish

Memo

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M112148

0.00

Powdercoat

Memo

Powder Coating

START TIME:

8:20

OVEN TEMPERATURE:

320° FINISH TIME:

8:50

BR 09-12-2

(121)

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/12/02

X121

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54008

November 25, 2009 3:05:01 PM



Page 3

Item ID: D2594-1  
Revision ID: C  
Item Name: Plug, 205 Skidtube

Accept



Setup Start



Stop



Start Date: 11/25/09 Start Qty: 120.00  
Required Date: 11/30/09 Req'd Qty: 120.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Packaging

Identify as per dwg & Stock Location

FP-A

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

BL 09-12-2 (121) /

09/12/03

mf 09-12-02

# Picklist Print

November 25, 2009 3:04:59 PM

Page 1

Work Order ID: 54008

Parent Item: D2594-1RevC

Parent Item Name: Plug, 205 Skidtube


Comments:

Start Date: 11/25/09

Required Date: 11/30/09

Start Qty: 120.00

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			110	f	108.3857	6.5811			
												
6061-T6 Round Bar .625"												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	108.3857	
109733	5.72	
110250	11.79	
111650	14.6157	
- 112611	16.26	
112697	60	

6.8 Pt 5A09V11/26

108 ft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

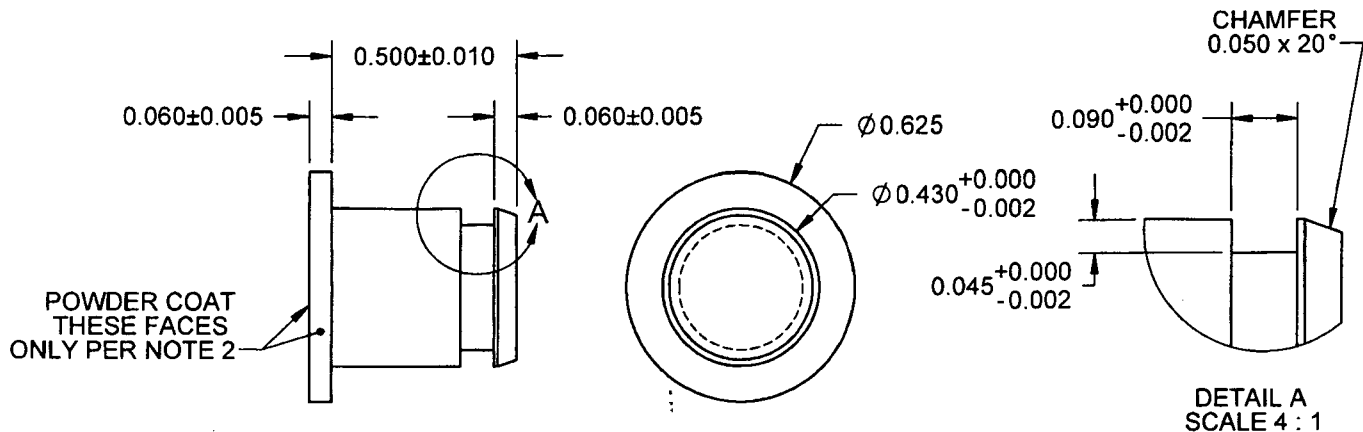






DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASE  
06.11.28 [Signature]



**D2594-1 PLUG**

**D2594-1 PLUG NOTES:**

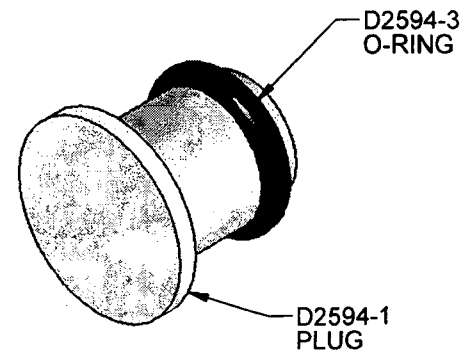
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle C$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



**D2594 PLUG ASSEMBLY**

COPYRIGHT © 1996 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.